Work Order ID 113212

113212

February-12-14 8:59:20 AM

Item ID: D4003-11 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Vent Pipe - Tank

Start Date: 2/14/14 **Start Qty:** 4.00 *4*

Required Date: 2/14/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** FF **Date:** 14-02-14 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4003	A								
100		0.00							FF 14-03-10
100						4			
Small Fab	**Memo**	0.00							
Small Fab	1- Cut tube xxx" long								
	2- Bend as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 27 9-89 14/3/10
110						4			
QC	**Memo**	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						4	SB 14-3-11		
HandFinish	**Memo**	0.00							
Hand Finishing									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Item ID: D4003-11 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Vent Pipe - Tank

Start Date: 2/14/14 **Start Qty:** 4.00 *4*
Required Date: 2/14/14 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				4			
160 QC Quality Control	**Memo**	0.00							
170	Identify as per dwg & Stock Location ST243	0.00				4X		14-3-11	DAS 26 9-89
170 Packaging Packaging	**Memo**	0.00							
180	QC21- Final Inspection - Work Order Release	0.00				MLJ	14-03-12		
180 QC Quality Control	**Memo**	0.00							

14-3-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

Picklist Print

February-12-14 8:59:23 AM

4

Work Order ID: 113212 *113212*

Parent Item: D4003-11 *D4003-11*

Parent Item Name: Vent Pipe - Tank

Start Date: 2/14/14 **Required Date:** 2/14/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP rev A 10.01.12 new issue prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.035		Purchased	No			100	f	101.0600	1.97	7.88			
M6061T6T0.500W.035									**		FF	14-03-10	
6061-T6 RD Tube .500 x.035W													

Location	Loc Qty	Loc Code	
MAT014	101.06		
121848	44.06		3.94
M127417	57		3.94

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

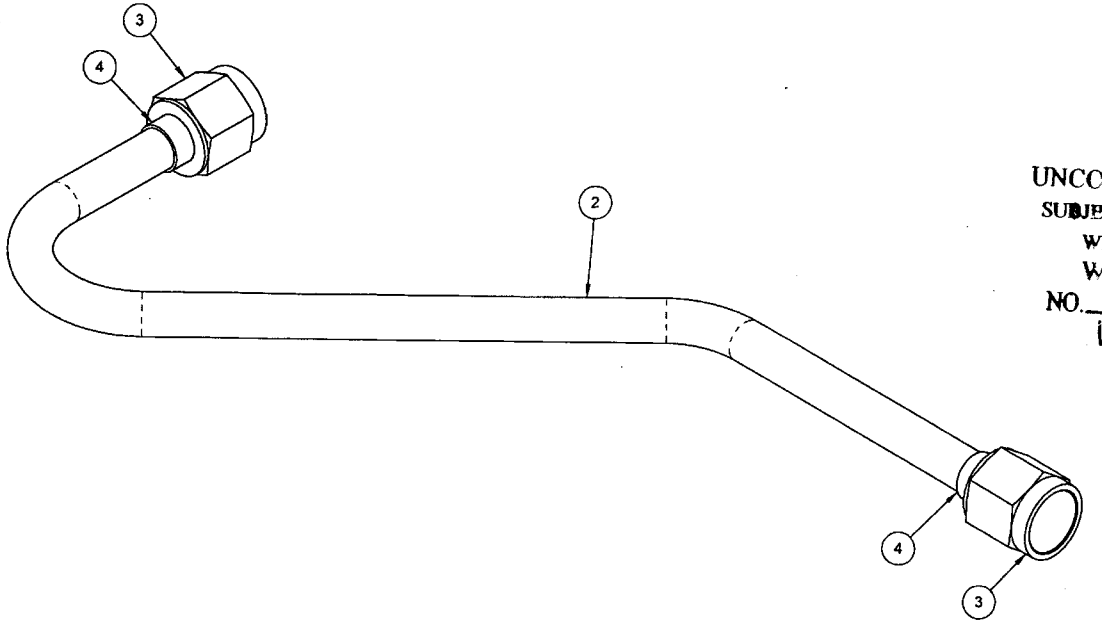
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-047	FUEL PUMP INLET PIPE	JCA-M47-2-16
2	1	D4003-7	FUEL INLET PIPE	
3	2	AN818-6D	NUT	
4	2	MS20819-6D	SLEEVE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED C
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 113212 MP
14-02-14

RELEASED
2010 -05- 05
MP

D4003-047 FUEL PUMP INLET PIPE

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-047" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.07 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		10.02.05

DESIGN	DART AEROSPACE LTD
DRAWN	HAWKESBURY, ONTARIO, CANADA
CHECKED	DRAWING NO. D4003 REV. A
MFG. APPR.	SHEET 1 OF 9
APPROVED	TITLE LINE SCALE NTS
DE APPR.	
DATE 10.02.05	

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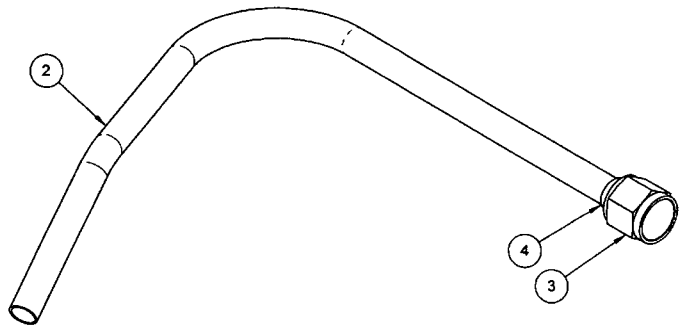
ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-049	TANK VENT LINE ASSEMBLY	JCA-M47-2-17
2	1	D4003-9	VENT LINE	
3	1	AN818-8D	NUT	
4	1	MS20819-8D	SLEEVE	



D4003-049 TANK VENT LINE ASSEMBLY

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.11 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.02.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4003 REV. A
SHEET 2 OF 9
TITLE LINE
SCALE NTS

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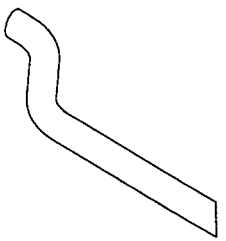
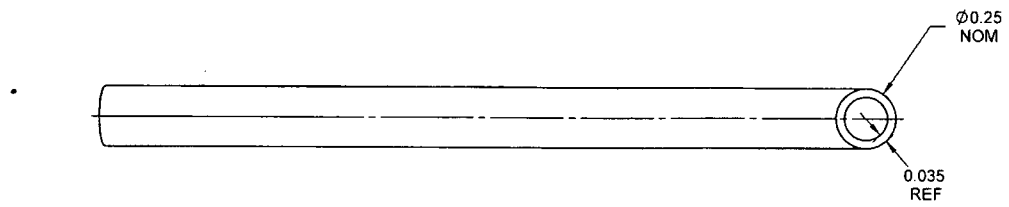
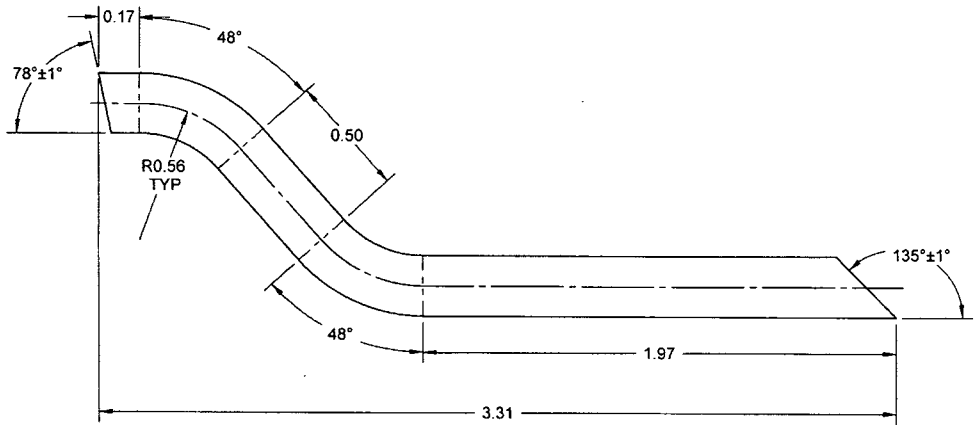
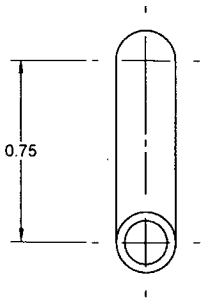
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-1	REF JCA-M47-1-06









RELEASED
2010 -05- 05

D4003-1 INTERNAL DRAIN LINE, AFT

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.25 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC 6061T6T0.250W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D4003 — REV. A
CHECKED		SHEET 3 OF 9
MFG. APPR.		TITLE LINE — SCALE NTS
APPROVED		
DE APPR.		
DATE	10.02.05	

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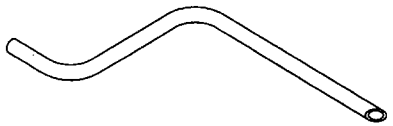
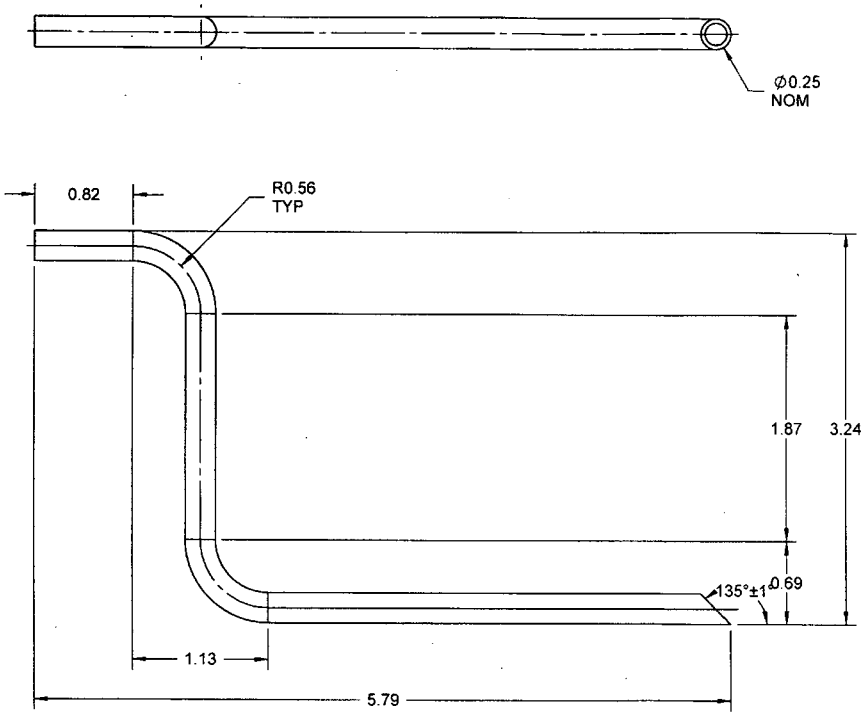
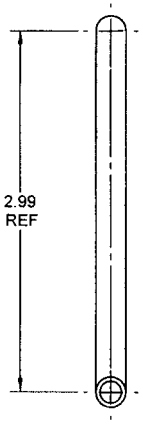
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-3	REF JCA-M47-1-15







D4003-3 INTERNAL DRAIN LINE, FWD

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.25 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC 6061T6T0.250W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4003 — REV. A
MFG. APPR.		SHEET 4 OF 9
APPROVED		TITLE LINE — SCALE NTS
DE APPR.		
DATE 10.02.05		

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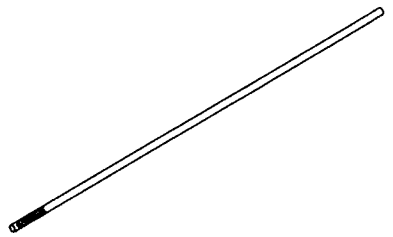
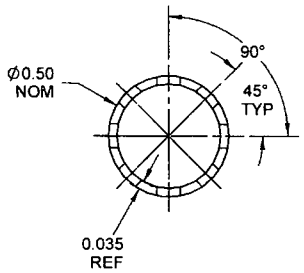
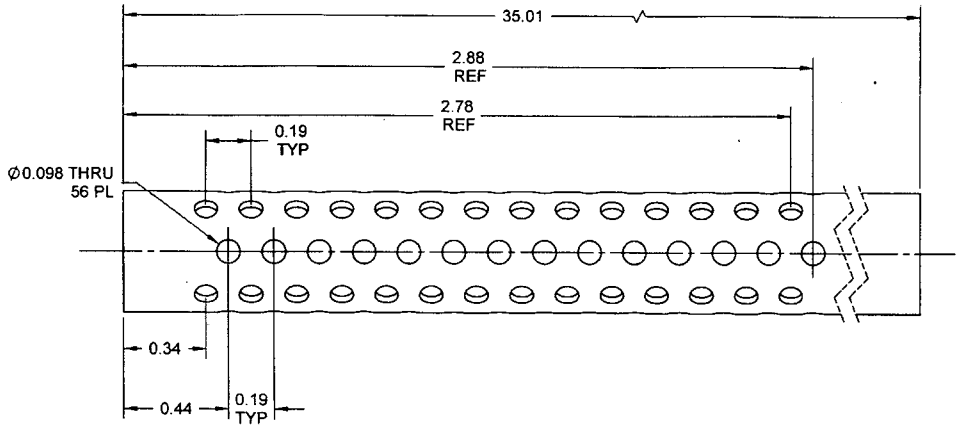
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-5	REF JCA-M47-1-10







D4003-5 FUEL PICK UP LINE

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
REF WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DAT SPEC M6061T6T0.500W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.17 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4003 REV. A
MFG. APPR.		SHEET 5 OF 9
APPROVED		TITLE LINE SCALE NTS
DE APPR.		
DATE 10.02.05		

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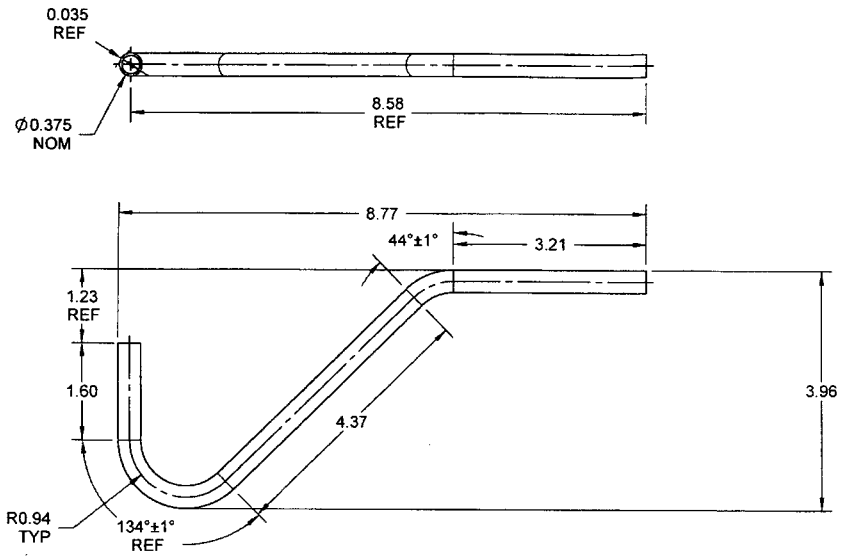
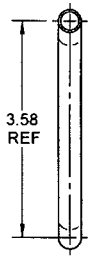
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-7	REF JCA-M47-2-16





D4003-7 FUEL INLET PIPE

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.375 X 0.035 WALL THICKNESS PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DART SPEC M6061T6T0.375W.035
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4003 REV. A
MFG. APPR.		SHEET 6 OF 9
APPROVED		TITLE LINE SCALE NTS
DE APPR.		
DATE	10.02.05	

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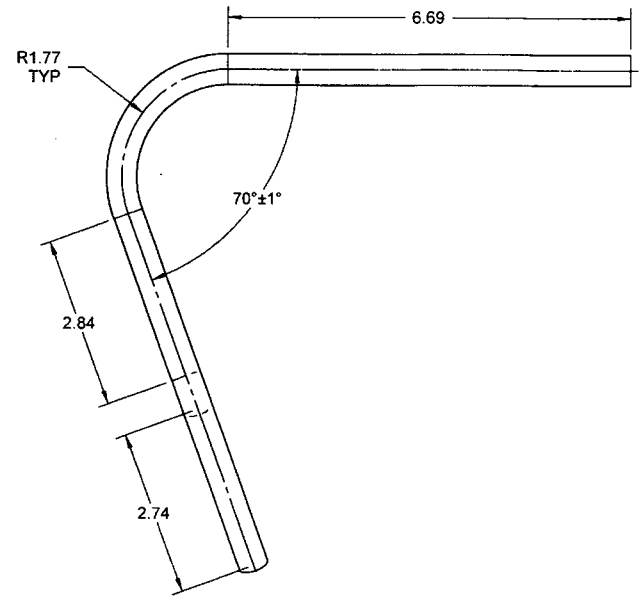
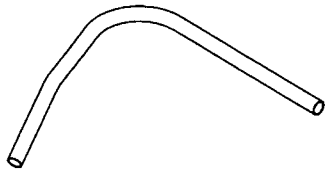
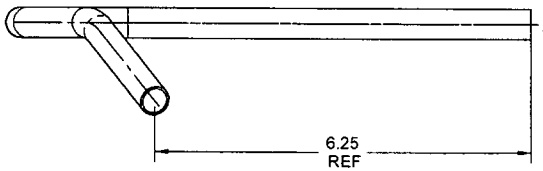
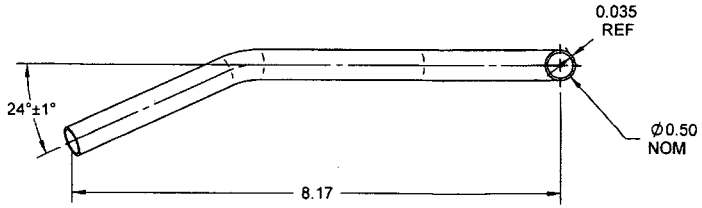
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-9	REF JCA-M47-2-17









D4003-9 VENT LINE

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4003 REV. A
MFG. APPR.		SHEET 7 OF 9
APPROVED		TITLE LINE SCALE NTS
DE APPR.		
DATE 10.02.05		

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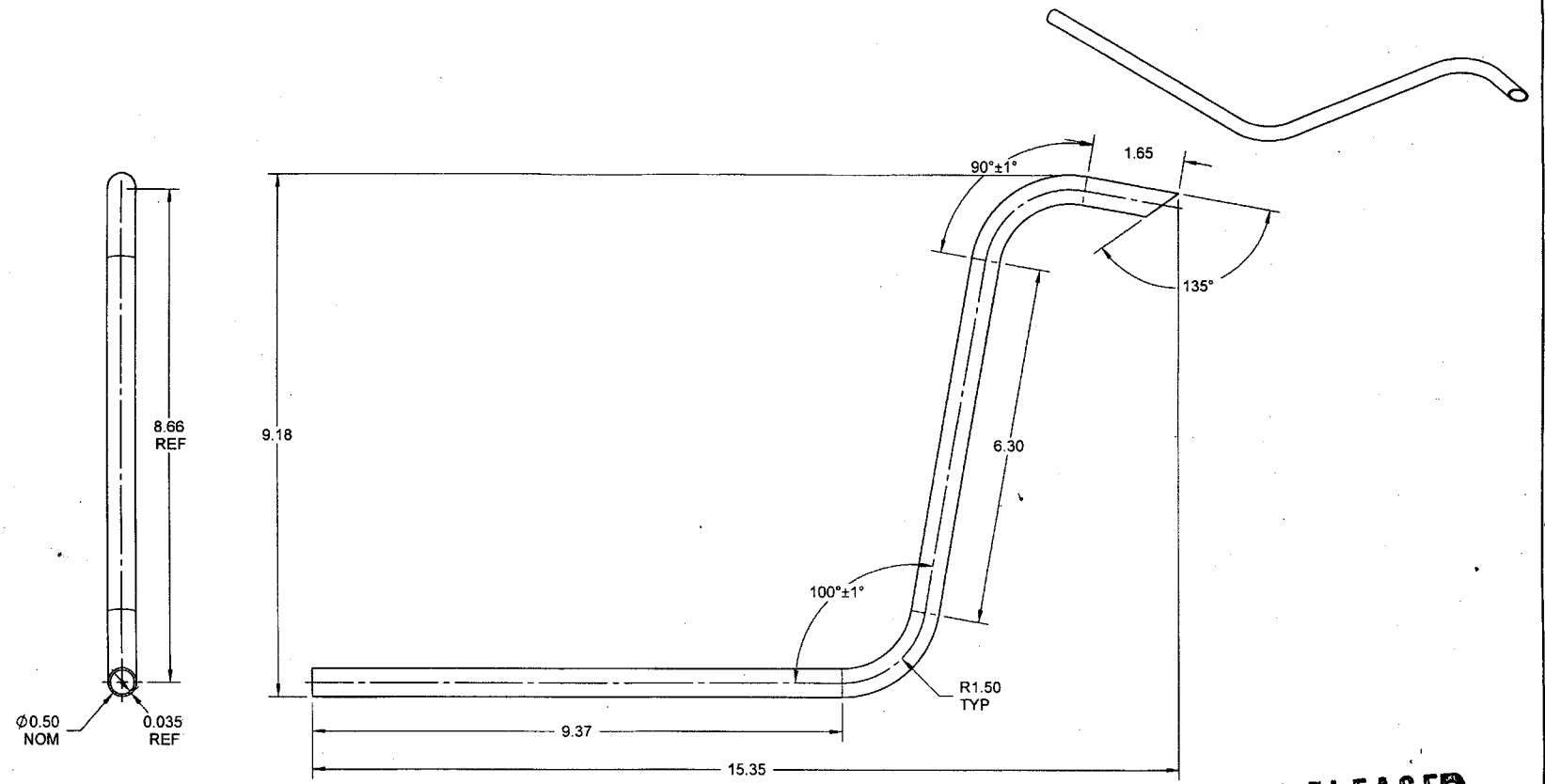
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-11	JCA-M47-2-21



D4003-11 VENT PIPE - TANK

RELEASED
2010 -05- 05
MP

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-11" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.11 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.02.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4003	REV. A
	SHEET 8 OF 9
TITLE LINE	SCALE NTS

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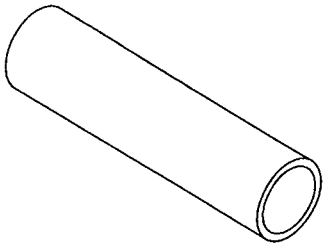
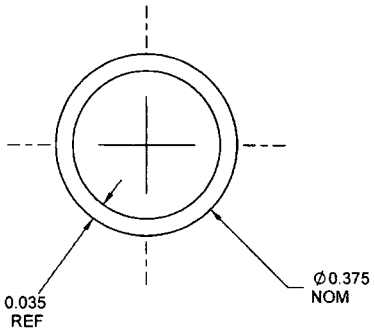
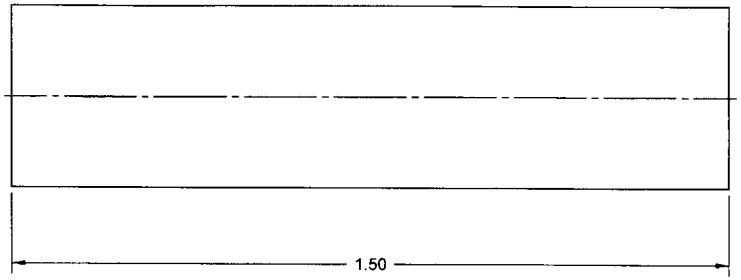
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-13	REF JCA-M47-2-22







D4003-13 FORWARD FUEL GUTTER LINE

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.375 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T0.375W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4003 REV. A
MFG. APPR.		SHEET 9 OF 9
APPROVED		TITLE LINE SCALE NTS
DE APPR.		
DATE 10.02.05		

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DART AEROSPACE LTD

Description: Vent Pipe Tank		Work Order:	113212
Inspection Drawing: D4003	Rev: A	Part Number:	D4003-11

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.37	± 0.030	9.37	✓		SFab-07	
6.30	± 0.030	6.30	✓		" -07	
1.65	± 0.030	1.65	✓		" -07	
9.18	± 0.030	9.18	✓		" -07	
15.35	± 0.030	15.35	✓		" -07	
100°	1°	100°	✓		SFab-05	
90°	1°	90°	✓		" -05	

Measured by:	Checked By: DAS 30 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*):
FF			
Date 14-03-10	Date 14/03/10	Date 14/3/10	Date